

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027929**Date Inspected:** 09-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Bonifacio Daquinag Jr.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS project**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector performed Ultrasonic Testing (UT) of Electro Slag Welding (ESW) joints in the Self Anchored Suspension (SAS) Tower, Shear Plates, for verification purposes at the locations listed below:

W-045 ("H"): This QA Inspector performed UT using a 70 degree shearwave transducer from Face B and observed both parallel and transverse recordable UT indications in the weld from Y-630 to Y-2700. A total of 3 areas were identified as having recordable UT indications; 2 areas contained longitudinal indications and 1 area contained a transverse indication. See Ultrasonic Testing Report (TL-6027) this date for further details.

E-045 ("F"): This QA Inspector performed UT using a 70 degree shearwave transducer from Face A and observed both parallel and transverse UT indications in the weld from Y-6000 to Y-7500. A total of 5 areas were identified as having UT indications; 1 area contained a longitudinal indication that did not meet the acceptance criteria and was classified as a Class-A defect and rejected, 2 areas contained longitudinal recordable indications and 2 areas contained transverse recordable indications. See Ultrasonic Testing Report (TL-6027) this date for further details.

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This QA Inspector was informed by Lead QC Inspector Bonifacio Daquinag Jr. this morning that QC Inspector Andrew Keech would not be available to work with this date. This QA Inspector performed UT which had previously been UT inspected by other QC personnel.

This QA Inspector did not observe welding being performed this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
